Work Grder ID 5013	Order ID 56131	Orde	rk (Wõ
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Page 1

February 10, 2010 2:52:03 PM

Item ID:

D205-634-041

Accept



Setup Start



Revision ID:

Item Name:

Replacement Skidtube

Start Date: Required Date: 2/26/10

2/10/10

Start Qty: 1.00

Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: QC:

Date://

Tooling:

Date:

Run

Start

Stop



Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID Operation Description Set Up/ **Run Hours** Draw Number Draw Rev.

Plan Accept Qty Code

Reject Qty

Reject Number

Insp. Stamp

Draw Nbr

Revision Nbr

D2580

Rev D

DOCUMENT CONTROL

DC

Memo

0.00

0.00

Document Control

Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG002

110

100

CNC Bend 1

CNC Delta 100 Bender

0.00

BENDING MACHINE - SKIDTUBES

Memo

0.00

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

10-2-18

Dart Aeros	pace Ltd
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W/O:			ORK ORDER CHANG	NGES					
DATE	STEP	PR	OCEDURE CH	IANGE	Ву		Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Ca	· · · · · · · · · · · · · · · · · · ·	NCD: V	a. Na	DOA	Data	
		colution:							
NCR:				DER NON-CONFORM					-
DATE	STEP	Description of NC Section A	Initial	Corrective Action Sec Action Description	ction B Sign &		Verification		Approval
<u> </u>		Occilon A	Chief Eng	Chief Eng	Da	ate	Section C	Chief Eng	QC Inspector
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Work Order ID 56131

Page 2

February 10, 2010 2:52:03 PM

Item ID:

D205-634-041

Accept



Setup Start

Stop



Revision ID:

Item Name:

Replacement Skidtube

Start Date: Required Date: 2/26/10

2/10/10

QC:

Start Qty: 1.00

Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Date:

Tooling:

Date:

Draw

Number

Date:

Draw

Rev.

Plan

Code

Run

Start

Reject

Stop

Reject

Qty

Number Stamp

Insp.

10-02-22

Sequence ID/ **Work Center ID**

120

Skidtubes Skidtubes

Operation Description Set Up/ **Run Hours**

0.00

SPC (Y/N):

0.00

Memo

1- Deburr ends

2- C'sink holes as per dwg without cutting fluid

3- Prepare tube for welding, remove alodine as required.

4- Scribe batch number insied aft end of tube.

130

OC5- Inspect part completeness to step on W/O

0.00



Quality Control

Memo

0.00

BE 10/04/a2

Accept Qty

Dart	Aer	OS	pace	Ltd
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W/O:			ORK ORDER CHANG	IGES					
DATE	STEP	PRO	OCEDURE CHA	CEDURE CHANGE			ate Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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					Σ				
Part No:		PAR #:	Fault Cate	gory:	NCR: Ye	s No	DQA:	_ Date: _	
Resolution:							Date:		
NCR:			WORK ORD	ER NON-CONFORM	ANCE (N	CR)			
DATE	STEP	Description of NC			tion B	Varitiaatian		Approval	Approval
	O I E I	Section A	Initial Chief Eng	Action Description Chief Eng	Sig Da	n&	Section C	Chief Eng	QC Inspector
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February 10, 2010 2:52:03 PM

Item ID:

D205-634-041

Accept



Setup Start

Stop



Revision ID:

Item Name:

Replacement Skidtube

2/10/10 **Start Date:**

Required Date: 2/26/10

Start Qty: 1.00

Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Date: SPC(Y/N):

Tooling:

Date:

Date:

Start Run

Stop



Sequence ID/ **Work Center ID**

140



Skidtubes

Skidtubes

Operation Description

Memo

Set Up/ **Run Hours** 0.00

Draw Number Draw Rev.

Plan Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

1-Weld step D2576 as per Dwg. D2580 and QSI 004
A/R \(\text{D} \text{ } \) Aluminum Rod

0.00

BG 10/03/20

2-Prep per OSI 005 and weld crossbolt spacers D2579 as per Dwg. D2580, QSI

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill A/R \(\square\) Aluminum Rod

3-Grind welds as per Dwg D2580 Grind flush ridge made from bending

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64", adjust stopper not to hit web.Deburr

5-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Deburr holes

6-Drill pilot holes for aft cap using DT 8215Open holes to 0.208". Deburr

7-Drill pilot holes for Tow ring using DT8091, open to .640" and Deburr

10-2-23

W/O:		WORK ORDER CHANGES									
DATE STEP		PROCEDURE CHANGE	PROCEDURE CHANGE By		E CHANGE By D		By Date		Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

NCR:57	131	W	ORK OR	DER NON-CONFORMANC	E (NCR)			
D.4.T.F	0750	Description of NC		Corrective Action Section B		Verification	Approval Chief Eng	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C		Approval QC Inspector
10/12/23	# 140.4	Apple employe Realizer plen he had spot Driles the The most & wear Plate hold that he had places the Drill Jig 0,7883) on the worning hole.	psione	Fill in the two \$30 holes with weld appr 027004 11/2 11/3207	उद्देश्य १५०३/२.५	G Jalos	Lonur	whoh3
		RC Lock of oftention when location Drile 3:4	Josiun	-Grinowall welds Pluch for	815 1969/24	Supr.	binne	8 10/12/73

February 10, 2010 2:52:03 PM

Item ID:

D205-634-041

Revision ID: Item Name:

Replacement Skidtube

Start Date:

Required Date: 2/26/10

2/10/10

Start Qty: 1.00

Req'd Qty: 1.00

Accept



Setup Start



Stop

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Date: ____

Tooling:

0.00

0.00

. ;

SPC (Y/N):

Date:

Date:

Run

Start

Stop



Sequence ID/

Work Center ID

150

Quality Control

Operation Description

QC10- Inspect visual per QSI004- ground welds

Memo

Set Up/ **Run Hours** Draw Number Draw Rev.

Plan Code

Reject Accept Qty Qty

Reject Number Stamp

160

Quality Control

OC5- Inspect part completeness to step on W/O

0.00

Pressure Wash per QSI005 4.3

Memo

Memo

PAR 09-043 BR 10-3-1 D

170

HandFinish Hand Finishing

W/O:		WORK ORDER CHANGES									
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву		Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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Part No	:	PAR #:	Fault Car	tegory:	NCR: Y	es N	o DQA :	Date: _			
				Disposition: Q			QA: N/C Closed: D				
NCR:		,	WORK ORI	DER NON-CONFORM	ANCE (N	CR)					
DATE	STEP	Description of NC	Corrective Action Section Initial Action Description			Circa e V			Approval		
	Section A	Section A	Chief Eng	Action Description Chief Eng	D	ate	Section C	Chief Eng	QC Inspector		

Work Order ID 56131



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Item ID:

D205-634-041

Accept



Setup Start



Revision ID:

Item Name:

Replacement Skidtube

Start Date:

Required Date: 2/26/10

2/10/10

Start Qty: 1.00

Req'd Qty: 1.00



Cust Item ID:

Customer:

Draw

Number

Reference:

Approvals:

Process Plan:

Date:_____

Tooling:

Date: _____

Draw

Rev.

Run

Start

Stop

Stop

Date:

SPC (Y/N):

Set Up/

Run Hours

Date:

Qty

Reject Accept Qty

Reject Number

Insp. Stamp

Sequence ID/ **Work Center ID**

180

Powdercoat

Powder Coating

Operation Description

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

1113170

0.00

0.00

7 16/10/03/02

Plan

Code

Memo

START TIME: OVEN TEMPERATURE: 320% FINISH TIME: 320% A

7:30Am

190

Memo

QC3- Inspect Part Finish

0.00

0.00

BR 10-03-2

Quality Control

	•							,			
W/O:			WC	RK ORDER CHANG	ES		······································				
DATE	STEP	PROCEDURE CHANGE				Date Q	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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						}					
		PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQA: _	Date: _				
	Res	olution:	Dispositio	Disposition: QA: N			A: N/C Closed: Date:				
NCR:			WORK ORDI	R NON-CONFORM	ANCE (NCR)					
DATE	STED	Description of NC	Corrective Action Section B			Verification	n Approval	Approval			
DATE	STEP Description of NC Section A		Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C		QC Inspector			
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February 10, 2010 2:52:03 PM

Item ID:

D205-634-041

Accept



Setup Start



Revision ID:

Item Name:

Replacement Skidtube

2/10/10 **Start Date:**

Start Qty: 1.00 Required Date: 2/26/10

Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Α	nn	rov	ais	:

Process Plan: Date:

Date: _____

Tooling:

Date:

Start

Stop

Stop



Sequence ID/ **Work Center ID**

200

HandFinish

Hand Finishing

Operation Description Set Up/ **Run Hours**

SPC (Y/N):

Draw Number Draw Rev.

Plan Code Accept Reject Qty

Qty

Run

Reject Number Stamp

Insp.

Memo

0.00

0.00

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of

Sikaflex expire date: _

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with

Sikaflex. Clean excess adhesive A/R U DU Sikaflex-291 /U #345000

Sikaflex expire date: 10/68

5-Wing Walk as per Dwg D2580 and QSI 005 4.4

W 10-08-2

W/O:			WC	ORK ORDER CHAN	GES			
DATE	STEP	PRO	OCEDURE CHA		By	Date Qt	y Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	Part No: PAR #:		Fault Cate	Fault Category: NCF			Date: _	31586M
	Resolution:			n:	QA: N/C C	osed:	Date: _	
NCR:		,	WORK ORD	ER NON-CONFORM	MANCE (NCF	?)		
DATE	STEP	Description of NC			ection B	Verificatio	n Approval	Approval
	JILI	Section A	Initial Action De Chief Eng Chief		n Sign 8 Date	Section C	Chief Eng	QC Inspector
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Work Order ID 56131 February 10, 2010 2:52:03 PM



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D205-634-041

Accept

Setup Start

Run

Revision ID:

Item Name:

Item ID:

Replacement Skidtube



Start Date:

2/10/10

Start Qty: 1.00

Cust Item ID: Customer:

Required Date: 2/26/10

Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

Date: ______ Tooling: Date: Date:

Start

Stop

Stop



Sequence ID/

Work Center ID

210

Quality Control

Operation Description

QC5- Inspect part completeness to step on W/O

Date:

Set Up/

SPC (Y/N):

Run Hours

Draw Number Draw Rev.

Plan Code Accept Oty **Qty**

Reject Reject

Insp. Number Stamp

Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for

Foreign objects per OSI 024

220

Packaging

Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPPD205-634-041 Location:

PPP Rev:

230

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

Memo

0.00

	•											
W/O:			WORK ORDER CHANGES									
DATE	STEP	PRO	OCEDURE CHAI	IGE	By Date				Approval Chief Eng / Prod Mgr	Approval QC Inspector		
Part No	:	PAR #:	Fault Cate	jory:	NCR	: Yes	No DQ	A:	Date:			
		esolution:										
NCR:			WORK ORDE	R NON-CONFORM	ANCE	(NCR)					
DATE	STEP	Description of NC			ction B		Verific	cation	Approval	Approval		
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Picklist Print

February 10, 2010 2:52:07 PM

Page 1

Work Order ID: 56131

D205-634-041

Parent Item Name:

Replacement Skidtube

Start Date: 2/10/10

Required Date: 2/26/10

Comments:

Parent Item:

IPP Rev:N□02.08.28□FP was QC5 in Step 27; Added QC5 to Step 30□KJ

Start Qty: 1.00

Required Qty: 1.00

IPP Rev. O 06.02.28 Added paperwork

IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Date

Component Item ID/

Replacement Mfg/

Bin Primary Last

Route 110

Unit of

Qty on

Remaining

Qty

Status

D2580-1

Manufactured

No

Each

5.0000

1.0000

205 Skidtube bent detail

Warehouse Location

Loc Qty

Main Warehouse

LG

54541

54697

5 2

2

Loc Code

D2576-3

Manufactured

1 Each

141.0000 1.0000



Step (maching detail)

Warehouse Loc Qty Loc Code Location

Main Warehouse

ST 141 94 46661 52215 47

W/O:			WO	RK ORDER CHANG	ES						
DATE	STEP	PRO	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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Part No:		PAR #:	Fault Categ	jory:	_ NCR: Yes	No DQ	A:	_ Date: _	Date: Date: Approval Approval		
Resolution:			Disposition	n:	_ QA: N/C	Closed:		Date:			
NCR:		,	WORK ORDE	R NON-CONFORMA	NCE (NC	R)					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Description	on B Sign Dat	& Secti	cation ion C	Approval Chief Eng	Approval QC Inspector		
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February 10, 2010 2:52:07 PM

Work Order ID: 56131

Parent Item:

D205-634-041

Parent Item Name:

Replacement Skidtube

IPP Rev:N□02.08.28□FP was QC5 in Step 27; Added QC5 to Step 30□KJ Comments:

IPP Rev. O 06.02.28 Added paperwork EC

IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Replacement Mfg/

Manufactured

Bin Primary

Last

Route 140

Unit of Each

Qty on

Remaining 147.0000 20.0000

Qty

Start Date: 2/10/10

Start Qty: 1.00

Date Status

Required Date: 2/26/10

Required Qty: 1.00

Crossbolt Spacer

Component Item ID/

D2579

Warehouse	Loc Qty	Loc Code	
Location			
Main Warehouse			
LG	25		
51525	4		
53780	3		
54543	18		
Main Warehouse			
ST	122		
43988	4		
46434	4		
46956	2		
47797	9		
48272	2		
51314	71		
51315	30		



×20) It 19/02/22

W/O:			WO	RK ORDER CHANG	SES		· · · · · · · · · · · · · · · · · · ·		
DATE	STEP	PRO	OCEDURE CHAN	IGE	By Date Qty			Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No:		PAR #:	Fault Categ	ory:	NCR: Yes	No DQ	A:	_ Date:	
Resolution:			Disposition	:	_ QA: N/C C	losed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORM	ANCE (NCI	₹)	-		
DATE	STEP	Description of NC			tion B	Verifi	cation	Approval	Approval
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Picklist Print

February 10, 2010 2:52:07 PM

Work Order ID: 56131

Parent Item:

D205-634-041

Parent Item Name:

Replacement Skidtube

Comments:

IPP Rev:N□02.08.28□FP was QC5 in Step 27; Added QC5 to Step 30□KJ

IPP Rev. O 06.02.28 Added paperwork

IPP Rev:P 07-07-09 SS Wearplates & Gaskets

Start Date: 2/10/10

Required Date: 2/26/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ D2855

Replacement Mfg/ Manufactured

Bin Primary No

Last

Route 200

Unit of Each

Oty on 151.0000 1.0000

Remaining

Date

Qty

Status

Page 3

Cap

Warehouse Loc Qty Loc Code Location Main Warehouse ST026 151 50513 50770 51539 39 53791 110

AN3-5A

Bolt

No Purchased

200

Each

1,773.000 2.0000

Warehouse Location

Main Warehouse

ST 100188

105057

1773 188 1585

Loc Qty

Loc Code

2 bil 10-03-3

pf 10-03-3

	-								
W/O:			WO	RK ORDER CHANG	ES	*			,
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Part No:		PAR #:	Fault Cate	jory:	_ NCR: Yes	No DQ	A:	Date: _	
Resolution:									
NCR:		,	WORK ORDE	R NON-CONFORMA	NCE (NC	R)			
DATE	STEP	Description of NC		Corrective Action Section		Verifi	cation	Approval	Approval
DAIL	JILI	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Sect	ion C	Approval Chief Eng	QC Inspector
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February 10, 2010 2:52:07 PM

Work Order ID: 56131

Parent Item:

D205-634-041

Parent Item Name:

Component Item ID/

Replacement Skidtube

Comments:

IPP Rev:N□02.08.28□FP was QC5 in Step 27; Added QC5 to Step 30□KJ

IPP Rev. O 06.02.28 Added paperwork

Replacement Mfg/

IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Purchased

No

Bin Primary

Warehouse

Last

Route 200

Unit of Each

Qty on

Remaining 3,459.000 2.0000

Qty

Start Date: 2/10/10

Start Qty: 1.00

Date

Required Date: 2/26/10

Required Qty: 1.00

Status

Washer

AN960JD10L

Warehouse	Lo	e Oty	Loc Code	
Location				
Main Warehouse				
ST		3459		
101291		16		
105793		49		
110985		3394		2 AF 10-03-3.
	200	Each	986.0000 50	0000

Loc Code

ALS7-1032-130

Purchased

No

Loc Qty



Insert

	Location		
	Main Warehouse		50 Bil 10-03-3
1151 100 W	ST //0511	986	30 M 10 3
ALSH-1032-130.	108606	52	
,,,	111529	130	
	111779	34	
	112772	11	
	113238	759	

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W/O:			W	ORK ORDER CHANG	SES				3.		
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
Part No:		PAR #:	Fault Cat	egory:	_ NCR: Yes	s No DQ	A:	Date: _			
Resolution:							sed: Date:				
NCR:			WORK ORI	DER NON-CONFORM	ANCE (NO	R)					
DATE	STEP	Description of NC			tion B	Verifi	cation	Approval	Approval		
	J.L.	Section A	Initial Chief Eng	Action Description Chief Eng	Sigr Dat		ion C	Chief Eng	QC Inspector		
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February 10, 2010 2:52:07 PM

Work Order ID: 56131

Parent Item:

D205-634-041

Parent Item Name:

Replacement Skidtube

Comments:

IPP Rev:N□02.08.28□FP was QC5 in Step 27; Added QC5 to Step 30□KJ

IPP Rev. O 06.02.28 Added paperwork

IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Date: 2/10/10

Required Date: 2/26/10

Start Oty: 1.00

Required Qty: 1.00

Component Item ID/ AN3C4A

Replacement Mfg/ Purchased

Primary Bin No

Last

Route 200

Unit of Each

Oty on 1,263.000 50.0000

Remaining

Qty

Date Status

BOLT

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	1263	
112314	13	
112720	12	
112724 6	3	
112829	1	
112991	2	
113121	64	
113226	344	
113422	124	
113644	500	

#8 pk 10-03-3

AN960C10L

washer

Purchased

No

200

Each

200

Loc Oty

388.0000 50.0000

Loc Code

WAS 144 C0033

Warehouse Location **OFFSHORE**

FG

100 100 288

50. pt 10-03-3,

Main Warehouse ST

112116

112612

103585

113749

128

160

W/O:			W	ORK ORDER CHAN	GES				,	i.
DATE	STEP	PRO	OCEDURE CHA	NGE		By Date Qty Chief E			Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No:		PAR #:	Fault Cate	gory:	NCF	R: Yes I	No DQ	A:	Date:	
Resolution:			Dispositio	n:	QA:	N/C Clo	sed:		Date: _	
NCR:			WORK ORD	ER NON-CONFORM	IANCE	(NCR)		- 	
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DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti		Chief Eng	QC Inspector
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February 10, 2010 2:52:07 PM

Work Order ID: 56131

Parent Item:

D205-634-041

Parent Item Name:

Replacement Skidtube

IPP Rev:N□02.08.28□FP was QC5 in Step 27; Added QC5 to Step 30□KJ Comments: IPP Rev. O 06.02.28 Added paperwork

IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Date: 2/10/10

Start Qty: 1.00

Required Date: 2/26/10 Required Qty: 1.00

Date

Component Item ID/ D3566-13

Replacement Mfg/ Manufactured

Manufactured

No

Bin Primary Last

Route

200

Unit of Each

Qty on 83.0000

Remaining 1.0000

Oty

Status

Gasket

Warehouse	Lo	c Oty	Loc Code
Location			
Main Warehouse			
FP /		81	
53461		81	
Main Warehouse			
ST		2	
45717		1	
50265		1	
	200	Each	34.0000

1 pt 10.03-3

1.0000

Gasket

D3566-5

Warehouse Location	Loc Qty	Loc Code	
Main Warehouse			
FP19	30		1/18/10-3-3
55026	18		_ 1 12 10 2 2
55335	12		
Main Warehouse			
ST	4		
36113	1		
46186	1		
47318	1		
51260	1		

W/O:			WC	ORK ORDER CHAN	GES					
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No	:	PAR #:	Fault Cate	gory:	NCR: Ye	s No DQ	A:	Date: _	<u> </u>	
		solution:								
NCR:			WORK ORDI	ER NON-CONFORM	MANCE (NO	R)				
DATE	STEP	Description of NC Corrective Action			ection B	Verific	Verification Approv		l Approval	
DAIL	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sigr Dat	l& Secti	ion C	Chief Eng	QC Inspector	
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Picklist Print

Page 7

February 10, 2010 2:52:07 PM

Work Order ID: 56131

Parent Item:

D205-634-041

Parent Item Name:

Replacement Skidtube

IPP Rev:N□02.08.28□FP was QC5 in Step 27; Added QC5 to Step 30□KJ Comments: IPP Rev. O 06.02.28 Added paperwork

IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Date: 2/10/10

Start Qty: 1.00

Required Date: 2/26/10

Required Qty: 1.00

Component Item ID/ D3566-1

Replacement Mfg/ Manufactured

Bin No

No

Manufactured

Primary

Last

Route 200

Unit of Each

Qty on 39.0000

Remaining 2.0000

Qty

Date

Status

Gasket

Warehouse	Loc	: Oty	Loc Code		
Location					
Main Warehouse					
FP		34			
52512		3			
54480		1			
55011		3			
55320 🗸		27			2 pt 10-03-3
Main Warehouse					•
ST		5			
46349		1			
51218		1			
51259		3			
	200	Each	5.0000	1.0000	

D3564-11

Wearshoe

Warehouse	Loc Qty	Loc Code	
Location			
Main Warehouse			1 pt 16-03-3.
FP19 55332	3		
52125	3		
Main Warehouse			
ST	2		
45823	1		
50112	1		

W/O:			W	ORK ORDER CHANG	GES	3-T-11-	35515		J
DATE	STEP	PRO	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			-						
Part No		PAR #:							
	Re	solution:	Dispositio	n:	QA: N/C	Closed: _		Date: _	
NCR:			WORK ORD	ER NON-CONFORM	ANCE (NO	CR)			
DATE	STEP	Description of NC	Description of NC Corrective Action		ction B	rification Approval		Approval	
		Section A	Initial Chief Eng	Action Description Chief Eng	Sigi Da	1 & S	ection C	Chief Eng	QC Inspector
· · · · · · · · · · · · · · · · · · ·									

February 10, 2010 2:52:07 PM

Work Order ID: 56131

Parent Item:

Comments:

D205-634-041

Parent Item Name:

Replacement Skidtube

IPP Rev:N□02.08.28□FP was QC5 in Step 27; Added QC5 to Step 30□KJ IPP Rev. O 06.02.28 Added paperwork

IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Date: 2/10/10

Required Date: 2/26/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ D3564-13

Replacement Mfg/ Manufactured

Manufactured

Bin Primary

No

ST

44659 45825

Last

Route 200

Unit of Each

Each

2

Qty on 23.0000

Remaining 1.0000

Qty

Date

Status

Wearshoe

Warehouse	Loc Oty	Loc Code
Location		
Main Warehouse		
FP17 /	11	
51611	11	
Main Warehouse		
ST ·	12	
45409	2	
46495	10	

200

Dr. 103.3

D3564-9

Wearshoe

1.0000

14.0000

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
FP19	12	
55025	12	
Main Warehouse		

1 BR10-03-3

W/O:			W	ORK ORDER CHANG	iES				Æ
DATE	STEP	PR	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
									
Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQ	A:	Date:	
		solution:							
NCR:			WORK ORD	ER NON-CONFORM	ANCE (NCF	?)			
DATE	STEP	Description of NC Corrective Action			ion B	Verific	ation	Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Secti	on C	Chief Eng	QC Inspector

February 10, 2010 2:52:07 PM

Work Order ID: 56131

Parent Item:

D205-634-041

Parent Item Name:

Comments:

Replacement Skidtube

IPP Rev:N□02.08.28□FP was QC5 in Step 27; Added QC5 to Step 30□KJ IPP Rev. O 06.02.28 Added paperwork

IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Date: 2/10/10

Required Date: 2/26/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ D3564-5

Replacement Mfg/ Manufactured

No

Bin Primary

Last

Unit of Each

Route

200

Qty on 44.0000

Remaining 1.0000

Qty

Date

Status

A 1840KA KABA KKAK ALIMA BUJU DIPI KIAPPI ANI 1841

Wears	shoe		

Warehouse	Loc Qty	Loc Code	
Location			
OFFSHORE			
FG	2		
34806	2		
Main Warehouse			
FP19	40		
51925	1		bl 10-03-3.
54772√	13		
55024	12		·
55333	14		
Main Warehouse			
ST	2		
45824	1		
47433	1		

Dart Aerospace	Ltd	
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		W	ORK ORDER CHANG	ES	• ••	1.5	· · · · · · · · · · · · · · · · · · ·	
STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Reso							Date: _	
		WORK ORD	ER NON-CONFORMA	ANCE (NCF	R)			
STEP	Description of NC			Verific	ication Approval		Approval	
	Section A	Chief Eng	Action Description Chief Eng	Sign & Date	Secti	on C	Chief Eng	QC Inspector
								-
				:				
		:PAR #: Resolution: STEP Description of NC	PAR #: Fault Cate Resolution: Disposition WORK ORD STEP Description of NC Section A Initial	STEP PROCEDURE CHANGE PROCEDURE CHANGE Fault Category: Resolution: Disposition: WORK ORDER NON-CONFORMA STEP Description of NC Section A Initial Action Description	PAR #: Fault Category: NCR: Yes Resolution: Disposition: QA: N/C CI WORK ORDER NON-CONFORMANCE (NCR STEP Description of NC	STEP PROCEDURE CHANGE By Date PAR #: Fault Category: NCR: Yes No DQ. Resolution: Disposition: QA: N/C Closed: WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC Section A	STEP PROCEDURE CHANGE By Date Qty	STEP PROCEDURE CHANGE By Date Qty Chief Eng/Prod Mgr

February 10, 2010 2:52:07 PM

Work Order ID: 56131

Parent Item:

D2594-3

D205-634-041

Parent Item Name:

O-Ring, 205 Skidtube

Replacement Skidtube

IPP Rev:N□02.08.28□FP was QC5 in Step 27; Added QC5 to Step 30□KJ Comments: IPP Rev. O 06.02.28 Added paperwork

IPP Rev:P 07-07-09 SS Wearplates & Gaskets

Component Item ID/

Replacement Mfg/

Manufactured

Bin Primary No

Last

JLM

Route 200

Unit of Each

Qty on

Loc Code

Remaining 668.0000 16.0000

Qty

Start Date: 2/10/10

Start Qty: 1.00

Date Status

Required Date: 2/26/10

Required Oty: 1.00

Warehouse	Loc Qty
Location	
Main Warehouse	
FP	527
51613	27
55546	500
Main Warehouse	
ST	141
52562	141

16. Bil 10-3.3.

W/O:			WC	RK ORDER CHANGE	:c				
DATE	STEP	PR	PROCEDURE CHANGE				Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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			1600						
Part No		PAR #:							
	Res	olution:						Date: _	
NCR:			WORK ORDI	ER NON-CONFORMA	NCE (NCR)	-		
DATE	STEP	Description of NC	Initial	Corrective Action Section		Verific	cation	Approval	Approval
		Section A	Chief Eng	Action Description Chief Eng	Sign & Date	Secti	on C	Chief Eng	QC Inspector

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Work Order ID: 56131

D205-634-041

Parent Item Name:

Replacement Skidtube

Comments:

Parent Item:

IPP Rev:N□02.08.28□FP was QC5 in Step 27; Added QC5 to Step 30□KJ

IPP Rev. O 06.02.28 Added paperwork

SS Wearplates & Gaskets

IPP Rev:P 07-07-09

JLM

Start Date: 2/10/10

Required Date: 2/26/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ D2594-1

Replacement Mfg/

Manufactured

Primary Bin

Last

Route 200

Unit of Each

Remaining Qty on 705.0000 16.0000

Qty

Date Status

Plug, 205 Skidtube

Warehouse	Loc Qty	Loc Code	
Location			
Main Warehouse			
FP	577		
54008	1		
54643	15		- blue s
55002	561		16. Dt 10-0
Main Warehouse			
ST	128		
42221	16		
42807	92		
43884	3		
46435	2		
51527	9		
51757	6		

W/O:			WC	ORK ORDER CHANG	ES				•
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
									,
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	_ Date: _	·
·	Re	esolution:	Disposition	າ:	QA: N/C C	osed:		Date: _	
NCR:		•	WORK ORDI	ER NON-CONFORMA	NCE (NCF	₹)			, a, i
DATE	STEP	Description of NC		Corrective Action Section		Verific	cation	Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date		on C	Chief Eng	QC Inspector
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					i	1			I.



DESIG	##	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECH	(ED ₄)	APPROVED	DRAWING NO. REV. D
	T		D2580 SHEET 1 OF 3
DATE			TITLE SCALE
07.0	2.27		205 SKIDTUBE ASSEMBLY NTS
Α		96.09.16	NEW ISSUE
В		96.12.02	AS MANUFACTURED
O		98.08.26	REDRAWN, INCLUDED DEO 9094/9097
D		07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183



QTY -041	QTY -045	Part Number	Description
Х		D2580-041	SKIDTUBE ASSEMBLY
	Х	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130	INSERT
Ī		or AKS7-1032-130	
		or AKS4-1032-130	
		or AELS-1032-130	
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

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ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 3443

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:

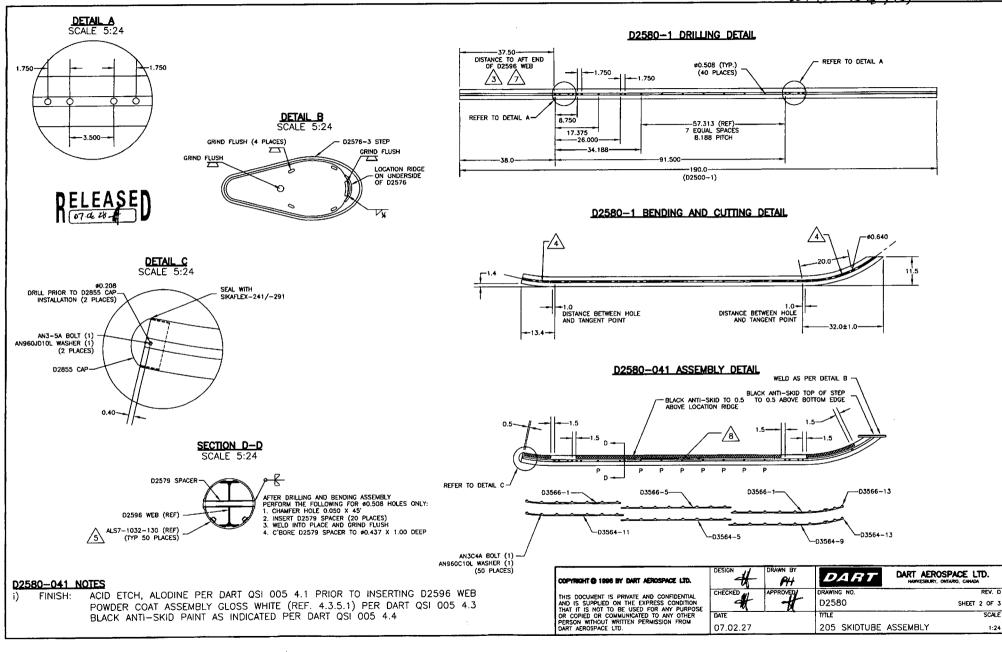
SEE NOTES ON PAGE 2 FOR D2580-041 AND PAGE 3 FOR D2580-045

 INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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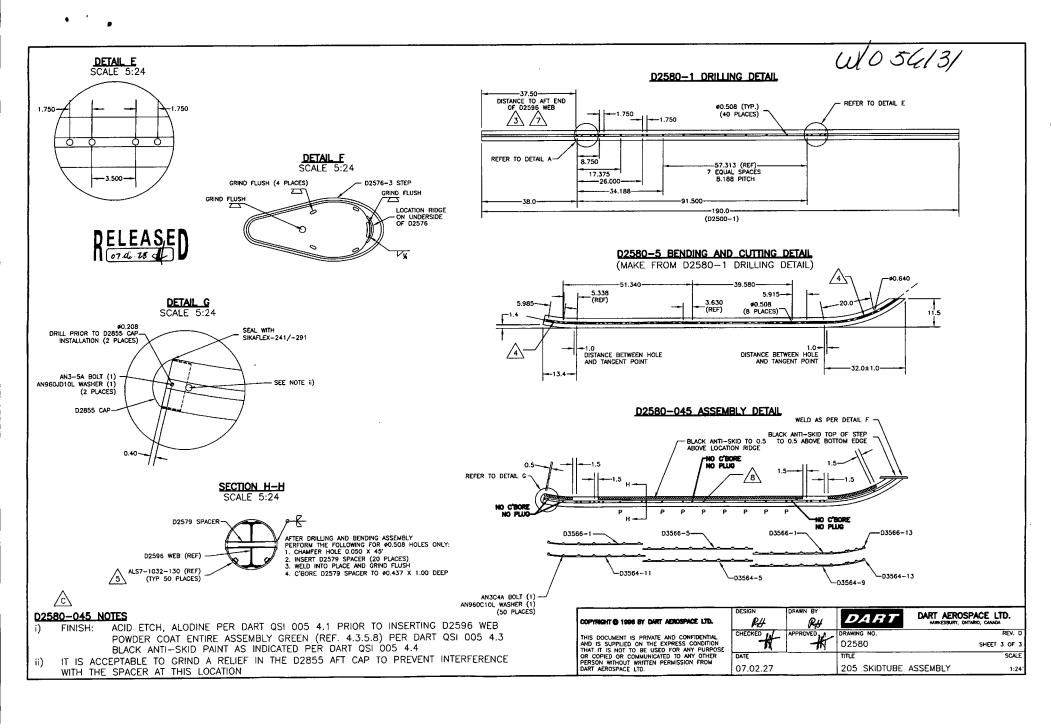
Dart Aerospace	e Ltd
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W/O:			W	ORK ORDER CHANG	ES				• ,
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQA	۸:	_ Date:	
		esolution:							
NCR:		,	WORK ORD	ER NON-CONFORMA	ANCE (NCR	3)			
DATE	STEP	Description of NC			ion B	Verific	ation	Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section		Chief Eng	QC Inspector
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Dart Aerospace Ltd	Dart	Aeros	pace	Ltd
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W/O:			W	ORK ORDER CHANC	GES	7,	· · · · · · · · · · · · · · · · · · ·	,
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	·	PAR #:	Fault Cat	egory:	NCR: Yes I	No DQA:	Date:	· · · · · · · · · · · · · · · · · · ·
	Re	esolution:	Dispositi	on:	_ QA: N/C Cld	sed:	Date: _	
NCR:		\	WORK ORE	DER NON-CONFORM	ANCE (NCR)		
DATE	STEP	Description of NC	Initial		tion B	Verification	Approval	Approval
		Section A	Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
		•						



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W/O:			W	ORK ORDER CHAN	IGES					· ·
DATE	STEP	PR	OCEDURE CHA	NGE	Ву		Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	gory:	NCR: Ye	es No	DQ.	4 :	Date:	
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DATE	STEP	Description of NC			ection B		Verific	ation	Approval	Approval
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		,								
					-					

NO. AZL

AWS D17.1.2001 QUALIFICATION TEST RECORD

Name: Bardan Elliett
Job number: 56 184
Part number: D205 634.041
Description: 205 skid tube
Welding Process: Tig[] Mig[] Base materiel: Alaman and a second a second and a second a second and a second
Current: AC[DC[]

TEST REQUIREMENTS AND RESULTS

Visual:	pass[] fail[]
Penetration:	pass[] fail[]
<u>UNACCEPTABLE</u>	
Cracks:	pass[/ fail[]
Undercut:	pass[] fail[]
Pin holes:	pass[4] fail[]
Overlap (cold lap)	pass[1 fail]
Porosity (surface):	pass[] fail[]
Coloration:	pass[fail[]
Qualifier	Date of Test Coupon 10. 02.23
Quantity 0 1/10 1	Date of Test Coupon 10.00.3.5
Welder David Chart	Date of Test Coupon 10-02-23

The above named individual is qualified in accordance with AWS D17.1.2001 to weld